



Dart Aerospace Ltd.
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D2274

Job Sheet 183507



Part No: D2274

Job Qty: 100 ea

Part Name: Radius Block



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 9/19/18

Job Tracking No:

Due Date: 10/12/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV F IPP H 00.05.18 Added inspection level 8 EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	100 Ea	10/12/18	10/12/18	0.00	0.00	Start Up Large Fab-7		SE 18/11/20
105	Waterjet - Flow - 1	100 pcs	10/12/18	10/12/18	0.00	0.00	Waterjet - Flow		SE 18/11/20
110	CNC Vertical Machining	100 pcs	10/12/18	10/12/18	0.01	2.39	HAAS 1		gm 18/11/28
130	QC	100 pcs	10/12/18	10/12/18	0.00	0.00	QC8		K 2018-11-28
140	Small Fab	100 pcs	10/12/18	10/12/18	0.00	0.54	Small Fab		SE 18/11/28
150	HandFinish	100 pcs	10/12/18	10/12/18	0.00	0.26	HandFinish1		P.R 18/11/29
160	QC	100 pcs	10/12/18	10/12/18	0.00	0.00	QC7		38
170	Packaging	100 pcs	10/12/18	10/12/18	0.00	0.00	Packaging3		NOV 29 2018
180	QC21-SA	100 Ea	10/12/18	10/12/18	0.00	0.00	QC21		NOV 29 2018

Part Op 105 - CUT BLANK blanks 9.00" long +/- 0.030" Note: 1 blank makes 9 pieces
Descriptions: 110 - Machine as per folio D2274
140 - Tumble Deburr any rough edges after tumbling

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6S.125	6061-T6 .125 Sheet	5 sf (.05 ea) 1,544 (0.0052)	105-Waterjet - Flow - 1	5018009

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
105-Waterjet - Flow - 1	M6061T6S.125	5	13	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Radius Block	0.257inches + 0.005 - 0.000	0.262 0.257		
2	Radius Block	0.750inches ± 0.010	0.760 0.740		
3	Radius Block	0.375inches ± 0.010	0.385 0.365		
4	Radius Block	0.125inches ± 0.010	0.135 0.115		
5	Radius Block	0.750inches ± 0.010	0.760 0.740		
6	Radius Block	0.063inches ± 0.010	0.073 0.053		



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Container No: S129735



Part: D2274

Job No: 183507

Serial No/Batch: S129735

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 11/20/18

TO 898-11-58
JAN 11/1/18